INCOMING INSPECTION

AQL Sampling Table Cheat Sheet

ISO 2859-1 / ANSI Z1.4 single sampling, normal inspection, general level II

QM Bench pocket guide
Rev. 2026-11

Single sampling, normal inspection, general level II

Columns = AQL in %.

Lot size	Code	0.065	0.1	0.15	0.25	0.4	0.65	1	1.5	2.5	4	6.5
2–8	A	100 %	100 %	100 %	100 %	100 %	100 %	100 %	100 %	**5** 0/1	**3** 0/1	**2** 0/1
9–15	B	100 %	100 %	100 %	100 %	100 %	100 %	**13** 0/1	**8** 0/1	**5** 0/1	**3** 0/1	**2** 0/1
16–25	C	100 %	100 %	100 %	100 %	100 %	**20** 0/1	**13** 0/1	**8** 0/1	**5** 0/1	**3** 0/1	**8** 1/2
26–50	D	100 %	100 %	100 %	100 %	**32** 0/1	**20** 0/1	**13** 0/1	**8** 0/1	**5** 0/1	**13** 1/2	**8** 1/2
51–90	E	100 %	100 %	**80** 0/1	**50** 0/1	**32** 0/1	**20** 0/1	**13** 0/1	**8** 0/1	**20** 1/2	**13** 1/2	**13** 2/3
91–150	F	100 %	**125** 0/1	**80** 0/1	**50** 0/1	**32** 0/1	**20** 0/1	**13** 0/1	**32** 1/2	**20** 1/2	**20** 2/3	**20** 3/4
151–280	G	**200** 0/1	**125** 0/1	**80** 0/1	**50** 0/1	**32** 0/1	**20** 0/1	**50** 1/2	**32** 1/2	**32** 2/3	**32** 3/4	**32** 5/6
281–500	H	**200** 0/1	**125** 0/1	**80** 0/1	**50** 0/1	**32** 0/1	**80** 1/2	**50** 1/2	**50** 2/3	**50** 3/4	**50** 5/6	**50** 7/8
501–1,200	J	**200** 0/1	**125** 0/1	**80** 0/1	**50** 0/1	**125** 1/2	**80** 1/2	**80** 2/3	**80** 3/4	**80** 5/6	**80** 7/8	**80** 10/11
1,201–3,200	K	**200** 0/1	**125** 0/1	**80** 0/1	**200** 1/2	**125** 1/2	**125** 2/3	**125** 3/4	**125** 5/6	**125** 7/8	**125** 10/11	**125** 14/15
3,201–10,000	L	**200** 0/1	**125** 0/1	**315** 1/2	**200** 1/2	**200** 2/3	**200** 3/4	**200** 5/6	**200** 7/8	**200** 10/11	**200** 14/15	**200** 21/22
10,001–35,000	M	**200** 0/1	**500** 1/2	**315** 1/2	**315** 2/3	**315** 3/4	**315** 5/6	**315** 7/8	**315** 10/11	**315** 14/15	**315** 21/22	**200** 21/22
35,001–150,000	N	**800** 1/2	**500** 1/2	**500** 2/3	**500** 3/4	**500** 5/6	**500** 7/8	**500** 10/11	**500** 14/15	**500** 21/22	**315** 21/22	**200** 21/22
150,001–500,000	P	**800** 1/2	**800** 2/3	**800** 3/4	**800** 5/6	**800** 7/8	**800** 10/11	**800** 14/15	**800** 21/22	**500** 21/22	**315** 21/22	**200** 21/22
500,001 +	Q	**1250** 2/3	**1250** 3/4	**1250** 5/6	**1250** 7/8	**1250** 10/11	**1250** 14/15	**1250** 21/22	**800** 21/22	**500** 21/22	**315** 21/22	**200** 21/22

Cell = **sample size n** and Ac/Re. Accept the lot when the number of defectives in the sample is ≤ Ac, reject at ≥ Re. Where an arrow in the master table sends you to another row, the sample size of that row is already shown. 100 % = inspect every part. If n is larger than your lot, inspect the whole lot.

How to use it

- Find your lot size row.
- Pick the AQL agreed with the customer (often 0.65 or 1.0 for major defects).
- Take **n** random parts from the whole lot, not only from the top.
- Count defective parts and compare with Ac / Re.
- Record lot, n, defectives and decision.

Switching rules (ISO 2859-1)

- **Normal → tightened:** 2 of 5 consecutive lots rejected.
- **Tightened → normal:** 5 consecutive lots accepted.
- **Normal → reduced:** switching score ≥ 30, steady production, approved by the responsible authority.
- **Reduced → normal:** one lot rejected or production irregular.
- **Stop:** 5 consecutive lots on tightened.

Remember: AQL is the worst average quality you tolerate as a process average, not a guarantee for one lot. With n = 125 and Ac = 3 (AQL 1.0) a lot with 2 % defectives is still accepted about 76 % of the time.

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